

Date: Wednesday, 5/31/2006 7:36:22 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BUSHING
Job Number	: 27286		
Estimate Number	: 10518		
P.O. Number	: N/A	Part Number	: D28063
This Issue	: 5/31/2006	S.O. No.	: N/A
Prsht Rev.	: NC	Drawing Number	: D2806 REV A
First Issue	: N/A	Project Number	: N/A
Previous Run	: 26160	Drawing Revision	: A
		Material	: N/A
Written By	: <u>SK COMMENT Below</u>	Due Date	: 6/18/2006
Checked & Approved By	: <u>9/06-05-31</u>	Qty:	40 Um: Each
Comment	: Est:B 05.03.11 Part now turned KJ/JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6H1000	6061-T6 1" HexBar
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Comment: Qty.: 0.0962 f(s)/Unit Total : 3.8472 f(s)

6061-T6 Hex Bar 1.0"

Material: 6061-T6 (QQ-A-200/8 or QQ-A-250/11) 1.00" Hex Bar

(M6061T6H1.000)

Batch: M19059J.G 06/06/05

2.0	HARDINGE	HARDINGE CNC LATHE SMALL
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Comment: HARDINGE CNC LATHE SMALL

1-Turn as per Folio FA105 and Dwg D2806

2-Tumble

J.G 06/06/05 40

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.G 06/06/05 40

4.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
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Comment: CONVENTIONAL MILLING MACHINE

Drill as per Dwg D2806

J.G 06/06/06 40

5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

9/06 06/06/06 40

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: SP Date: 06/06/09

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BUSHING

Job Number: 27286

Part Number: D28063

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

a.m

06-06-08

(40)

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT ALODINE

P/6/6/5

(40)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *57 386*

P/6/6/5

(40)

9.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06/06/09

(40)

Job Completion



u 06-06-09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

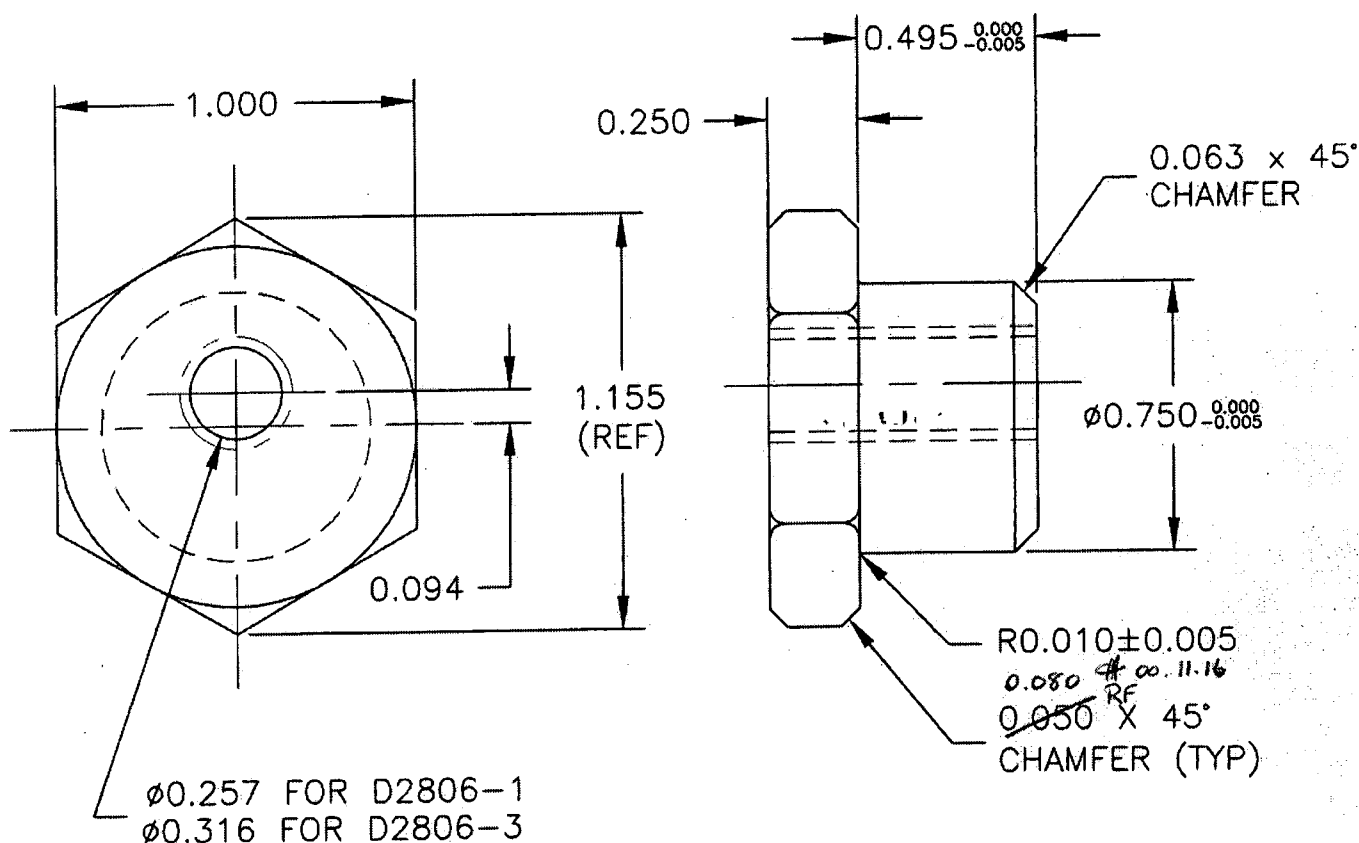
NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____



DESIGN #	DRAWN BY #	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED CP	APPROVED #	DRAWING NO. D2806	REV. A SHEET 1 OF 1
DATE 00.11.08		TITLE BUSHING	SCALE 2:1
A	00.11.08	NEW ISSUE	

RELEASED
00.11.13 #



D2806-1 (DRILL $\phi 0.257$ HOLE)
D2806-3 (DRILL $\phi 0.316$ HOLE)

MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11) OR (QQ-A-225/8)
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
BREAK ALL UNMARKED SHARP EDGES 0.010 TO 0.020
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 27286

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